

Date: Thursday, 12/04/2007 6:54:37 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 31806	
Estimate Number : 10530	
P.O. Number : N/A	Part Number : D2571
This Issue : 12/04/2007 S.O. No. : N/A	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 31719	Material : N/A
Written By : <u>W</u>	Due Date : 19/04/2007 Qty: 10 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: _____

R25355 5 07/04/21 X10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 131806 Double check by: JF

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

Ep SA
07/04/27

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

Ep SA
07/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/04/2007 6:54:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31806

Part Number: D2571

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Er / SN /
07/04/27

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 07/04/27 (10)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 07/04/30 (10X)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 103706

07-05-01 (10)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

Pc 7/5/02 (10)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

Pc 7/5/02 (10)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/05/02 (10)

Job Completion



07-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED

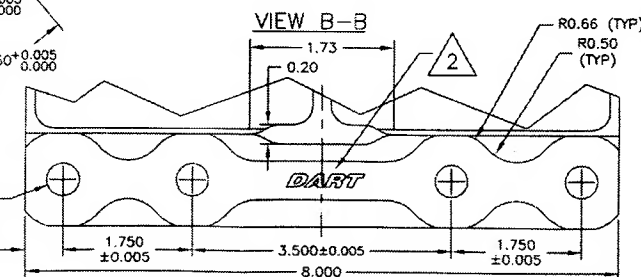
05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
 QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E



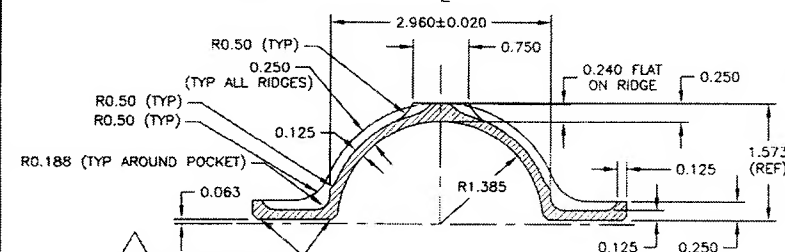
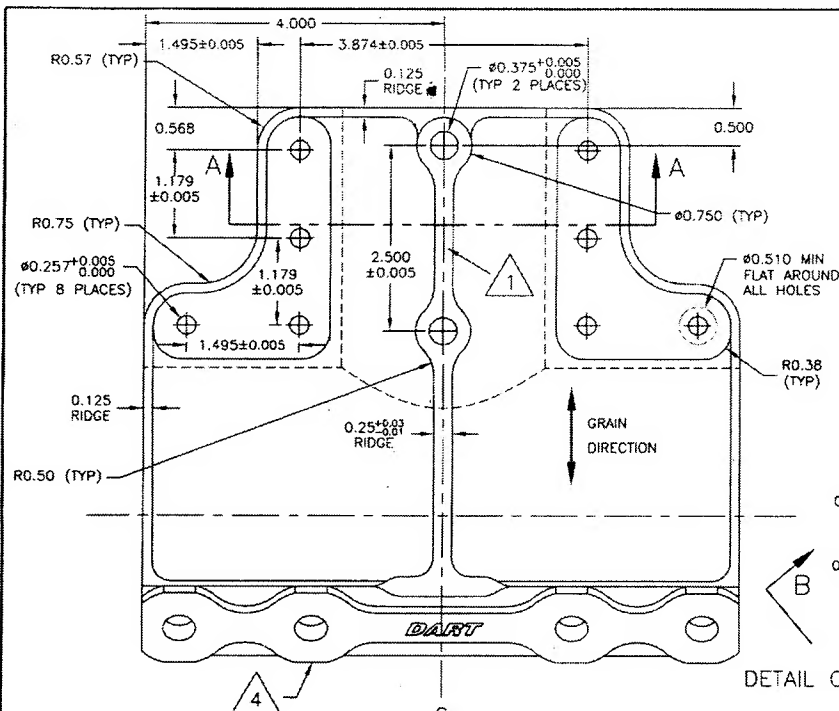
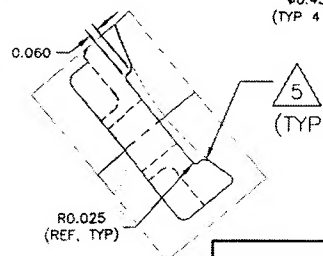
E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART DART AEROSPACE LTD. WARRICKBURY, OXFORD, CANADA	REV. E
CHECKED	#	APPROVED	#		
DATE	05.07.13	DRAWING NO.	D2571	SHEET 1 OF 1	SCALE
		TITLE	OUTER FWD SADDLE		2:3

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DETAIL C
 SCALE 4:3



4/03/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 31806
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.747	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.501		
D	1.745	1.755		1.749	1.747	1.748	1.748		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.499	0.498	0.498	0.494		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.502	0.501	0.501		
J	1.174	1.184		1.174	1.177	1.177	1.177		
K	0.558	0.578		0.564	0.565	0.563	0.565		
L	1.174	1.184		1.174	1.177	1.175	1.176		
M	1.490	1.500		1.495	1.492	1.494	1.492		
N	2.495	2.505		2.496	2.496	2.499	2.498		
O	3.869	3.879		3.870	3.870	3.871	3.871		
P	0.115	0.135		0.127	0.127	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.250	0.254		
S	0.115	0.135		0.127	0.131	0.131	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.961		
V	0.230	0.250		0.231	0.237	0.231	0.233		
W	0.115	0.135		0.121	0.121	0.121	0.121		
X	0.308	0.313		0.311	0.311	0.311	0.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.365	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.629	0.625	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.251	0.251	0.252		
AE	1.375	1.395		1.386	1.386	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.252	0.252	0.251		
AI	2.000	2.020		2.001	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: E. SA
Date: 07.07.24

Audited by: J.F.
Date: 07/04/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31806
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	0.440	0.440		
B	1.745	1.755		1.748	1.748	1.749	1.748		
C	3.495	3.505		3.499	3.499	3.499	3.498		
D	1.745	1.755		1.749	1.748	1.749	1.748		
E	7.990	8.010		8.002	8.001	8.002	8.004		
F	0.490	0.510		.494	.494	0.497	0.494		
G	0.257	0.262		.258	.258	0.260	0.260		
H	0.375	0.380		.376	.376	0.377	0.377		
I	0.490	0.510		.496	.496	0.500	0.501		
J	1.174	1.184		1.176	1.177	1.178	1.175		
K	0.558	0.578		.564	.564	0.567	0.563		
L	1.174	1.184		1.176	1.176	1.178	1.175		
M	1.490	1.500		1.494	1.495	1.495	1.494		
N	2.495	2.505		2.499	2.500	2.500	2.498		
O	3.869	3.879		3.871	3.871	3.872	3.871		
P	0.115	0.135		.124	.125	0.127	0.126		
Q	0.115	0.135		.135	.135	0.131	0.135		
R	0.240	0.260		.252	.253	0.252	0.252		
S	0.115	0.135		.125	.125	0.131	0.130		
T	0.178	0.198		.188	.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	0.236	0.237		
W	0.115	0.135		.132	.132	0.121	0.126		
X	0.308	0.313		.310	.310	0.311	0.311		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.365	.365	0.362	0.365		
AA	0.470	0.530		.500	.500	0.501	0.502		
AB	0.615	0.635		.627	.627	0.627	0.628		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.240	0.260		.247	.248	0.249	0.250		
AE	1.375	1.395		1.386	1.385	1.386	1.386		
AF	0.115	0.135		.135	.135	0.135	0.135		
AG	0.240	0.280		.258	.258	0.260	0.260		
AH	0.240	0.260		.246	.246	0.250	0.248		
AI	2.000	2.020		2.000	2.00	2.001	2.001		
AJ	0.023	0.043		.032	.032	0.033	0.033		
Accept/Reject									

Measured by: <u>En / MS</u>
Date: <u>07/04/25</u>

Audited by: <u>J.F.</u>
Date: <u>07/04/27</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31806
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

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B	1.745	1.755		1.748	1.750				
C	3.495	3.505		3.499	3.500				
D	1.745	1.755		1.748	1.750				
E	7.990	8.010		8.002	8.004				
F	0.490	0.510		0.497	0.493				
G	0.257	0.262		0.260	0.260				
H	0.375	0.380		0.377	0.377	7	c		
I	0.490	0.510		0.503	0.500				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		0.566	0.563				
L	1.174	1.184		1.178	1.178				
M	1.490	1.500		1.492	1.496				
N	2.495	2.505		2.499	2.497				
O	3.869	3.879		3.872	3.870				
P	0.115	0.135		0.127	0.126				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.253	0.252				
S	0.115	0.135		0.130	0.131				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.236	0.238				
W	0.115	0.135		0.120	0.124				
X	0.308	0.313		0.311	0.311				
Y	0.760	0.765		0.765	0.765				
Z	0.352	0.372		0.367	0.362				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.626	0.627				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.249	0.253				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		0.135	0.135				
AG	0.240	0.280		0.260	0.260		0.		
AH	0.240	0.260		0.253	0.252				
AI	2.000	2.020		2.001	2.000				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by:	SP
Date:	07/04/27

Audited by:	J.F.
Date:	07/04/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
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